

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021869**Date Inspected:** 07-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Xu Le Feng.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower and Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Shailesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector observed the following work in progress:

BAY 10, SMAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 057220 Perform Shielded Metal Arc Welding (SMAW) on OBG Cantilever beam. Joint identified as BK16B-001-012, 013, 014. ZPMC QC Identified as Yan Chang Fang. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2211-Tc-U5b.

This QA Inspector observed ZPMC qualified welding personnel identified as 040532 Perform Shielded Metal Arc Welding (SMAW) on OBG Cantilever beam. Joint identified as BK15B-001-015~020. ZPMC QC Identified as Yan Chang Fang. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2211-Tc-U4c.

This QA Inspector observed ZPMC qualified welding personnel identified as 053829 Perform Shielded Metal Arc Welding (SMAW) on OBG Bike Path. Joint identified as BK008A8-001-130. ZPMC CWI Identified as Guo Yan

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Fei. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2313-Tc-P4.

Repair Welding, SMAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 057258, 056364, 052493 Perform Shielded Metal Arc Welding (SMAW) on OBG Bike Path plate weld build up 7mm on the edge. Plate identified as BK008A6-001-007 and BK008A8-007-130. ZPMC CWI Identified as Guo Yan Fei with temporary welding repair report WRR-B-WR20365. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-2G(2F)-Repair and WPS-345-SMAW 3G (3F)-Repair. For more information see attached picture number 1.

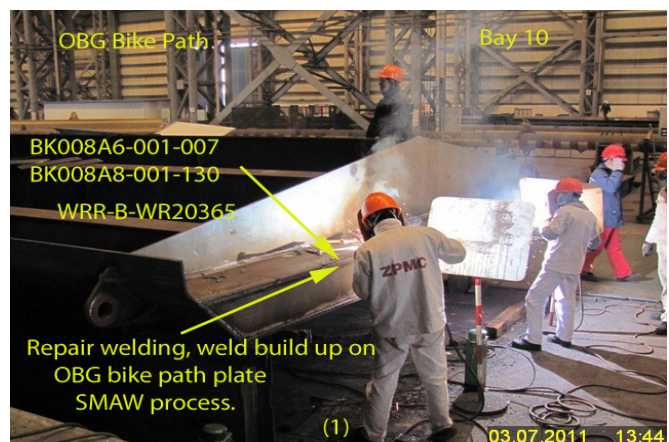
Repair Welding, SMAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 044511 Perform Shielded Metal Arc Welding (SMAW) on Tower Skirt plate, weld build up on hole area of skirt plate. Skirt Plate identified as SSD1-A544, SSD1-A434 and NSD1-A802. ZPMC QC Identified as Yu Zhi Lai with critical welding repair report CWR-T-CWR680. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-1G (1F)-Repair. For more information see attached picture number 2.

BAY 11, FCAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 040785 Perform Flux Core Arc Welding (FCAW) on OBG Bike path stringer plate. Joint identified as BK12A6-001-068, 069. ZPMC CWI Identified as Yu Dong Ping. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2132-ESAB.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Thomas Ho: 150002048250, who represents the Office of Structural Materials for your project.

Inspected By: Gaikwad,Shailesh

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer